

Rush ship 24-25/11

# Work Order ID 64011

November 23, 2010 7:02:32 AM



Page 1

Item ID: D3199-3

Revision ID:

Item Name: Bracket, Fwd LH

Start Date: 11/23/10 Start Qty: 8.00

Required Date: 11/25/10 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: *[Signature]*

QC:

Date:

Date:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3199

C

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D3199

Dwg Rev: *E*

Prog Rev: *C*

304 : 040

Deburr if required

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-1-23



B10-1-23

# Work Order ID 64011

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Page 2

Item ID: D3199-3

Accept

Revision ID:

Item Name: Bracket, Fwd LH

Start Date: 11/23/10 Start Qty: 8.00

Required Date: 11/25/10 Req'd Qty: 8.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Si 10/11/23



130

Bend as per dwg  
Small Fab

0.00



Brake NC

Memo

0.00

Brake NC

SB 10/11/23



140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Si 10/11/23



-33

# Work Order ID 64011

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Page 3

Item ID: D3199-3

Accept

Revision ID:

Item Name: Bracket, Fwd LH

Start Date: 11/23/10 Start Qty: 8.00

Required Date: 11/25/10 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

145



Small Fab

Small Fab

Memo

ROLL AS PER DWG

0.00

0.00

SB 10/11/23

8

147



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Swkltz

SB  
3

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

11/11/25 8%

Memo

START TIME: 8:00AM  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 8:30AM

0.00

0.00

=) 10/11/21

xs 7

# Work Order ID 64011

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Page 4

Item ID: D3199-3

Revision ID:

Item Name: Bracket, Fwd LH

Start Date: 11/23/10 Start Qty: 8.00

Required Date: 11/25/10 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Inst  
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 237

0.00

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

Accept

Setup Start

Stop

Cust Item ID:

Customer:

10/11/24 S/D 82

10/11/24 S/D 82

10/11/24 S/D 82

MF  
10-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November 23, 2010 7:02:31 AM

Page 1

Work Order ID: 64011

Parent Item: D3199-3

Parent Item Name: Bracket, Fwd LH



Start Date: 11/23/10

Required Date: 11/25/10

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: RevC-prelim DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	96.2000	0.3371	2.838737			



304/316 .040 Sheet



1810-11-23

Location

Loc Qty

Loc Code

MAT

92.2

115762

10.2

115953

82

MAT20

4

113062

1.398

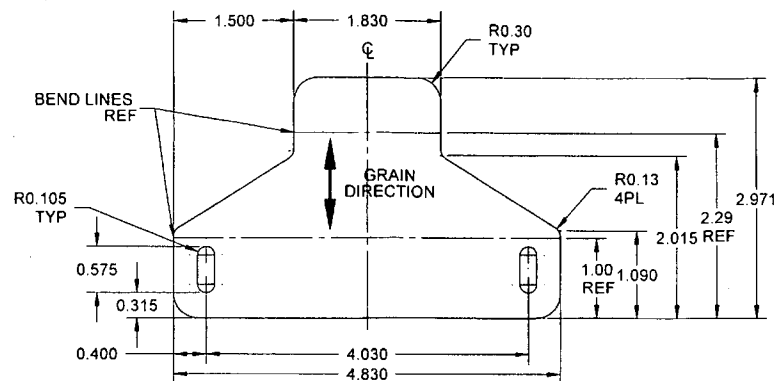
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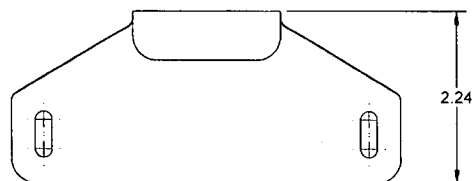
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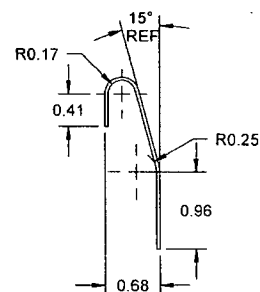




**D3199-1F FLAT PATTERN**



**D3199-1 BRACKET**  
MADE FROM D3199-1F



*velo  
64001*

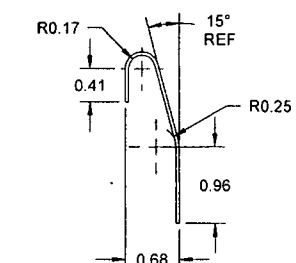
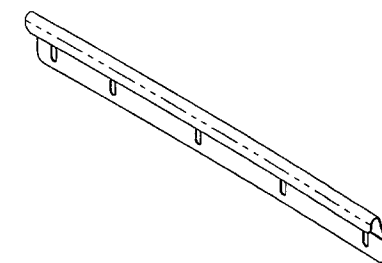
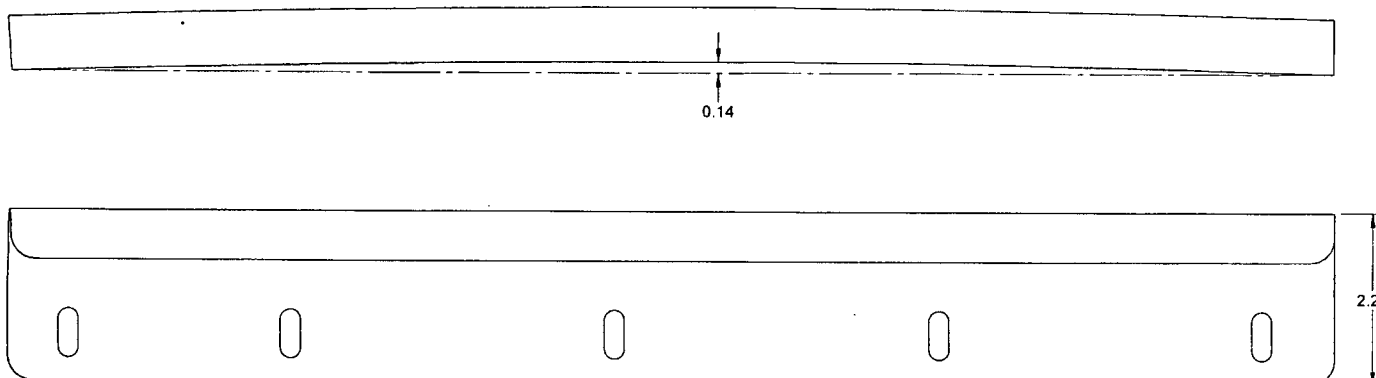
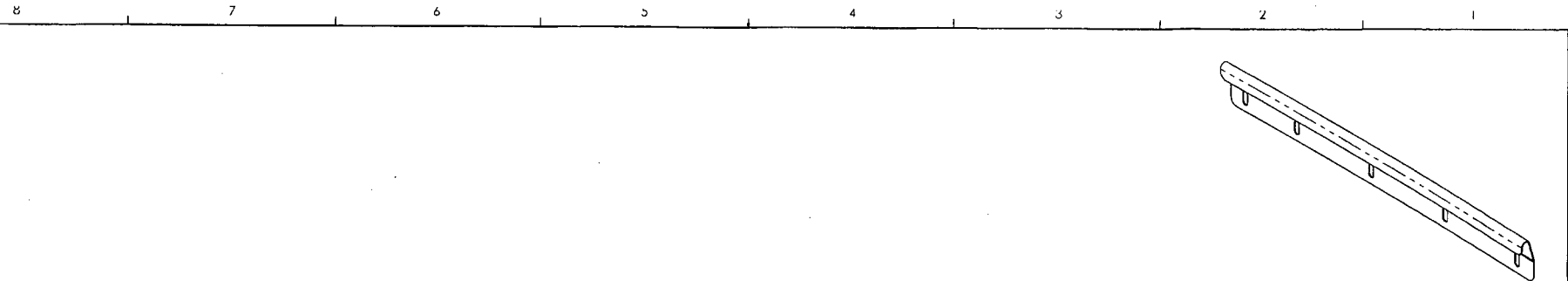
**RELEASED**  
2009-11-20  
*NW*

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH  
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S20GA
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

DESIGN	ADD -3/4 PART (SHEET 2-4)	09.11.19
DRAWN	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	06.11.01
CHECKED	NEW ISSUE	03.08.05
MFG. APPR.	REV.	DESCRIPTION
APPROVED	BY	DATE
DE APPR.	DATE	09.11.19
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3199</b> TITLE <b>BRACKET</b> SCALE <b>NTS</b> <small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		





**D3199-3 BRACKET**  
MADE FROM D3199-3F

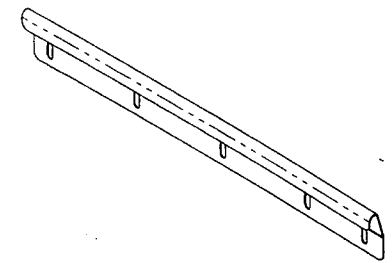
*old work*

**RELEASED**  
2009-11-20  
*MP*

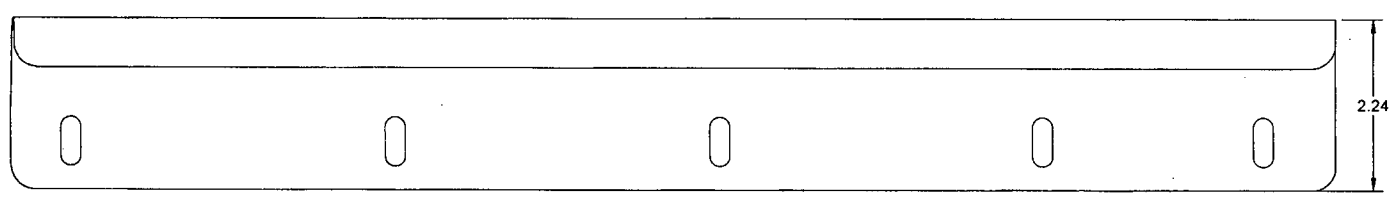
- NOTES:**
- 1) MATERIAL: MADE FROM D3199-3F
  - 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-3" AND B/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.55 lbs

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. C
MFG. APPR.	<i>[Signature]</i>	D3199 SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	BRACKET NTS
DATE	09.11.19	COPYRIGHT © 2003 BY DART AEROSPACE LTD
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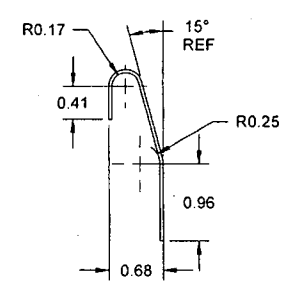
8 7 6 5 4 3 2 1



0.14



2.24



**D3199-4 BRACKET**  
MADE FROM D3199-3F

*also 6404*

**RELEASED**  
2009-11-20

- NOTES:**
- 1) MATERIAL: MADE FROM D3199-3F
  - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-4" AND B/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.55 lbs

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3199</b> REV. C
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE <b>BRACKET</b> SCALE
DE APPR.	<i>[Signature]</i>	NTS
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8 7 6 5 4 3 2 1



2009-11-2

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